

Work Order ID 130527

Friday, March 13, 2015 12:58:16 PM

130527

Page 1

Item ID: D5076-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MW Date: 15-03-13 Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5076	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1- Cut as per Dwg Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(7)

DC 15/03/18

(7)

DC 15/03/18

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Page 2

Item ID: D5076-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

MAR 19 2015

130

Form as per dwg
Small Fab

0.00

130

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

7

15/03/24

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
38
9-89

7

MAR 24 2015

Work Order ID 130527

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Page 3

Item ID: D5076-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

7 FF MAR 24 2015

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

(2) DAS 38 9-89 MAR 25 2015

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

Packaging

DAS 27 8-89

1.20

7 DAS 27 8-89 MAR 26 2015

Work Order ID 130527

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Page 4

Item ID: D5076-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

15/3/27 *[Signature]*
mf
15-3-25

Picklist Print

Friday, March 13, 2015 12:58:19 PM

Page 1

Work Order ID: 130527

130527

Parent Item: D5076-3

D5076-3

Parent Item Name: Bracket

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.04.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

sf

195.4306

3

M6061T6S 040

6061-T6 .040 Sheet

DL 15/03/18

Location

Loc Qty

Loc Code

MAT021

195.4306

m130312

6.1135

m130585

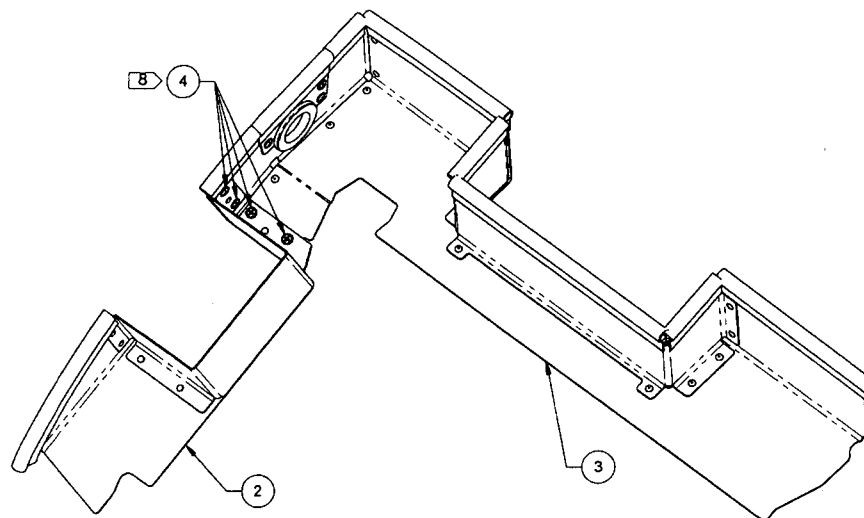
28.1501

m131352

161.167

5

ITEM	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D5076-041	FWD BRACKET ASSEMBLY
2	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
3	1	D5076-043	FWD INBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



D5076-041 FWD BRACKET ASSEMBLY

NOTES:

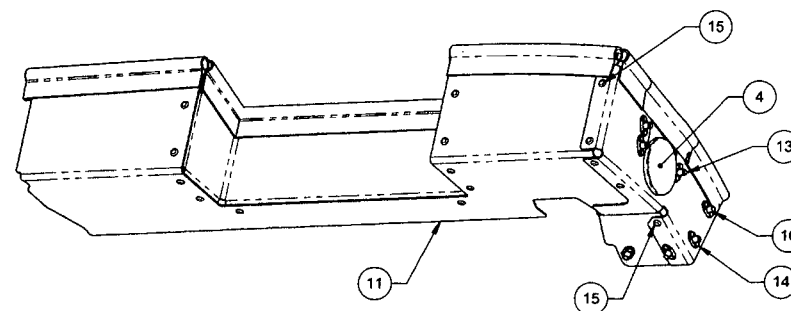
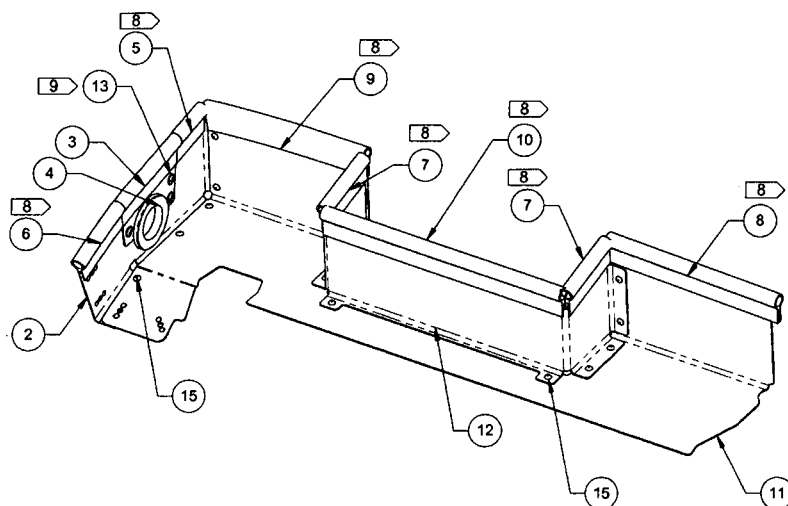
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.39 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

130527 MWS
1503-13

RELEASED
2014-03-31

A		NEW ISSUE		RF	14.03.11
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 7	
DRAWN	RF				
CHECKED	DC	DRAWING NO. D5076		SCALE	
MFG. APPR.	DD	TITLE BRACKET ASSEMBLY		NTS	
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DE APPR.	DS				
DATE		14.03.11			

ITEM	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D5076-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-9	BRACKET
3	1	D4435-041	BRACKET ASSEMBLY
4	1	D4440-1	GROMMET
5	1	D4441-1-017	RUBBER SEAL
6	1	D4441-1-025	RUBBER SEAL
7	2	D4441-1-026	RUBBER SEAL
8	1	D4441-1-067	RUBBER SEAL
9	1	D4441-1-064	RUBBER SEAL
10	1	D4441-1-094	RUBBER SEAL
11	1	D5076-1	BRACKET
12	1	D5076-3	BRACKET
13	3	AN525-832R6	SCREW
14	14	MS20426AD3-3	RIVET
15	15	MS20470AD4-3	RIVET
16	7	MS21075L08	NUT PLATE
17	A/R	3M 1300/1300L	ADHESIVE



D5076-043 FWD INBOARD BRACKET ASSEMBLY

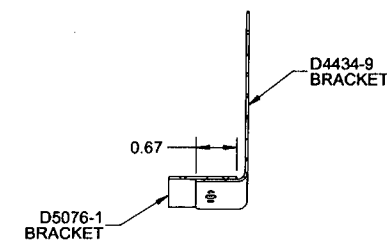
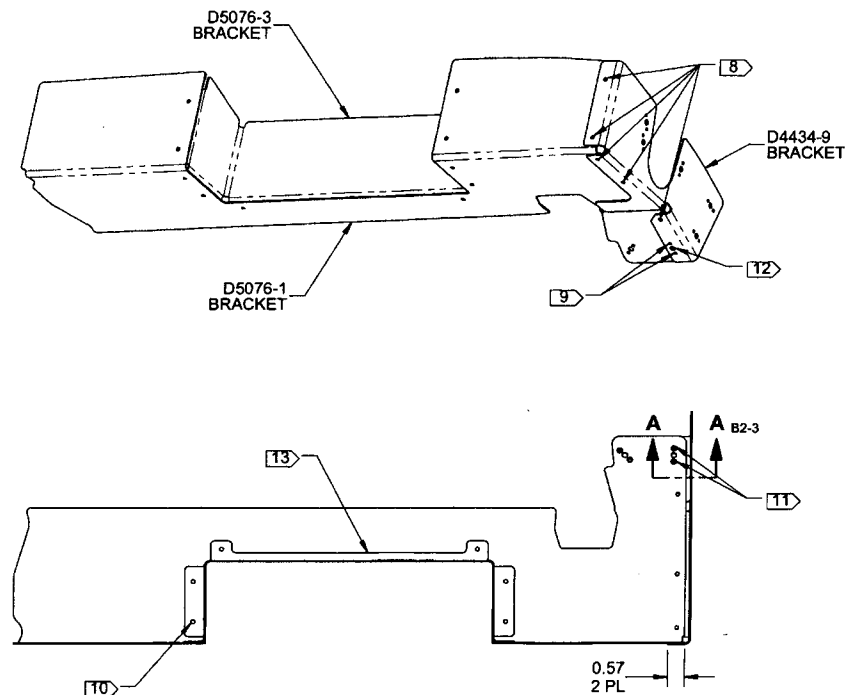
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 PRIOR TO INSTALLING D4435-041.
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE COVER IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

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2014-03-31

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MFG. APPR.	DD	D5076	SHEET 2 OF 7
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SECTION A-A C4-3

D5076-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) TRANSFER $\phi 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D5076-1
- 9) TRANSFER $\phi 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D5076-1
- 10) TRANSFER $\phi 0.129$ HOLES THRU 10 PLACES FROM D5076-3 TO D5076-1
- 11) CSK $\phi 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 12) TRANSFER $\phi 0.177$ HOLE THRU FROM D4434-9 TO D5076-1
- 13) CENTRE D5076-3 INTO OPENING OF D5076-1

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8 7 6 5 4 3 2 1

D

C

B

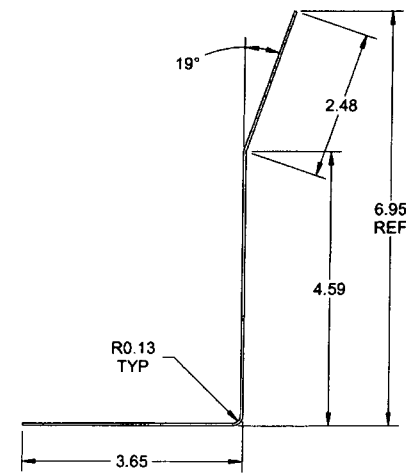
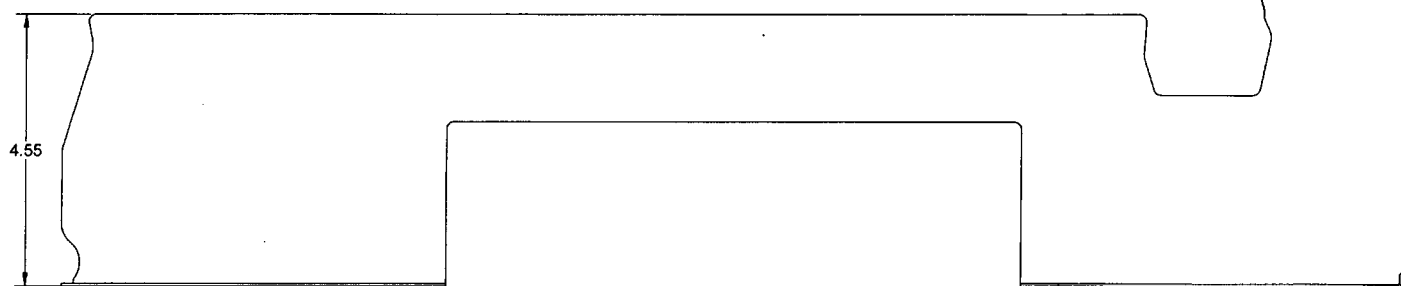
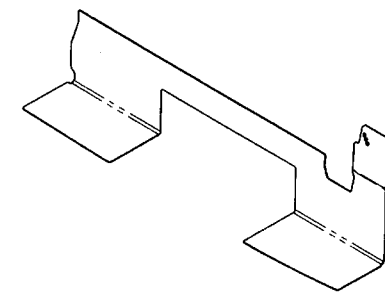
A

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D5076-1 BRACKET

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2014-03-31

NOTES:

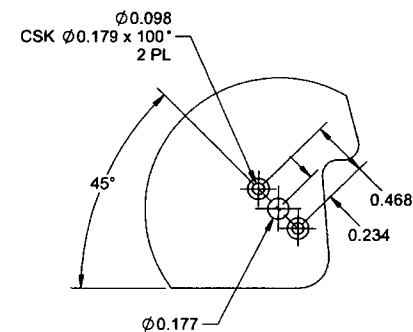
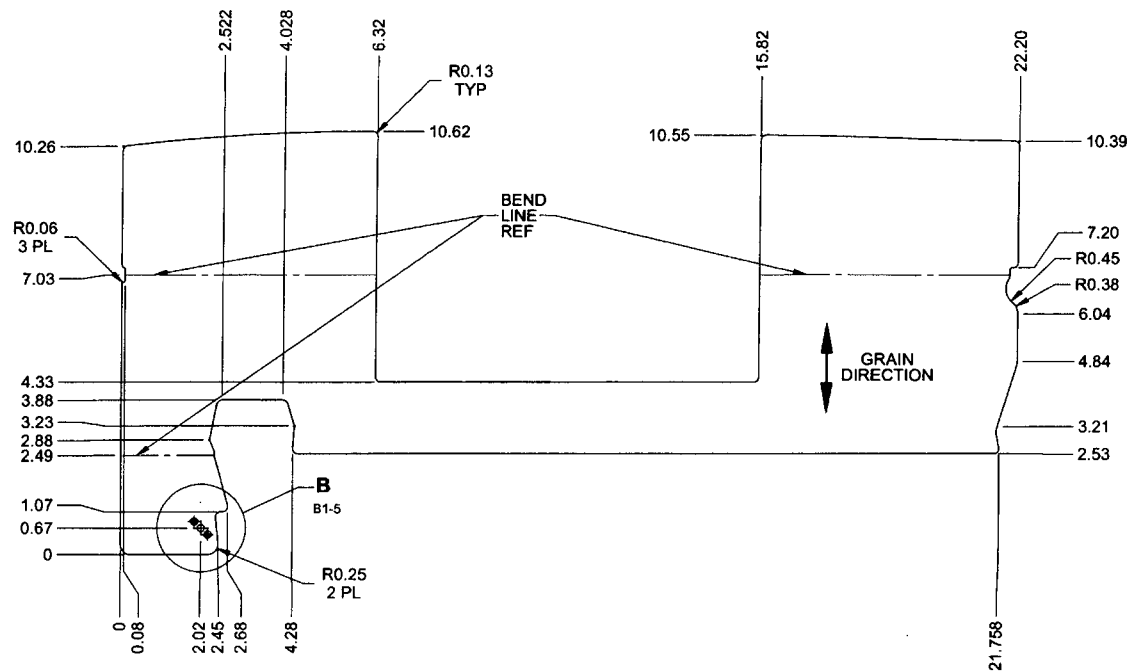
- 1) MATERIAL: MAKE FROM D5076-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

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DESIGN	RF
DRAWN	RF
CHECKED	DC
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	14.03.11

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D5076	REV. A SHEET 4 OF 7
TITLE BRACKET ASSEMBLY	SCALE NTS
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8 7 6 5 4 3 2 1



D5076-1F FLAT PATTERN BRACKET

DETAIL B B7-5

NOTES:

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

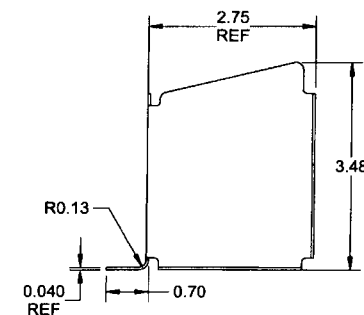
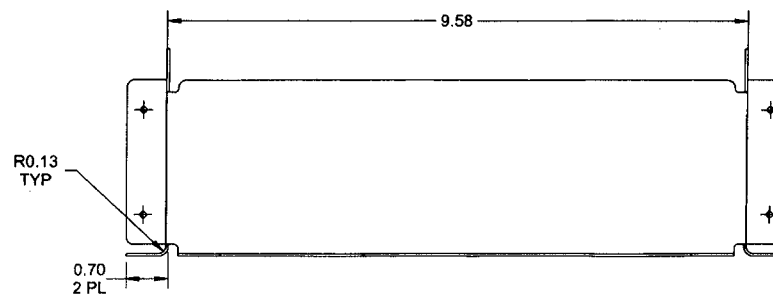
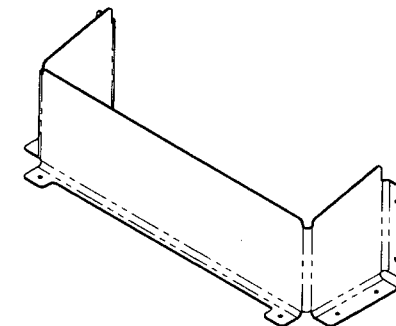
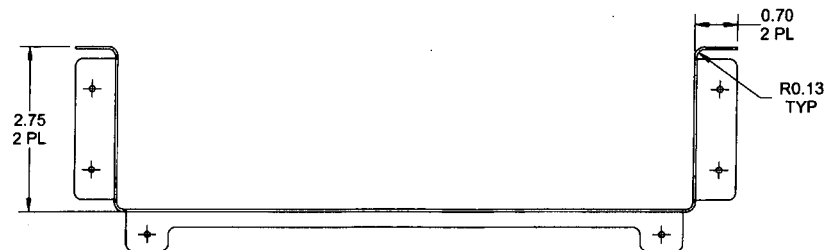
6) IDENTIFICATION: N/A

7) WEIGHT: 0.47 lbs

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2014-03-31

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 6 OF 7
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D5076-3 BRACKET

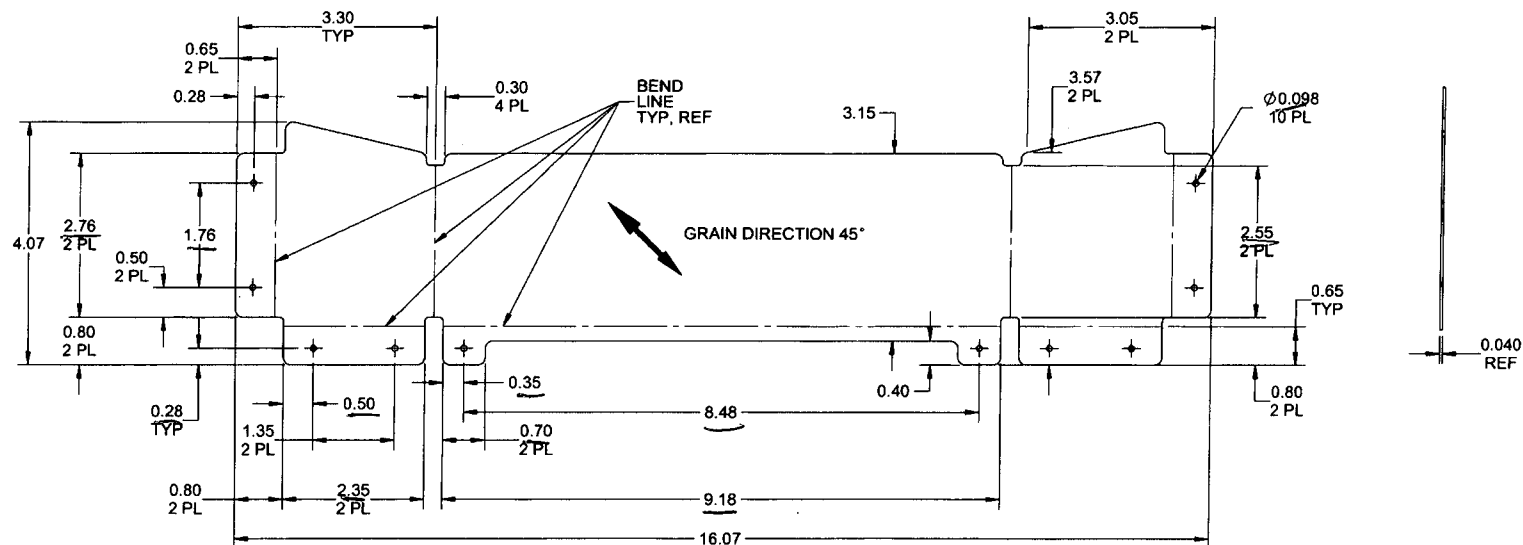
NOTES:

- 1) MATERIAL: MAKE FROM D5076-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

RELEASED
2014-03-31

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	DD	D5076	SHEET 6 OF 7
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D5076-3F FLAT PATTERN BRACKET

NOTES:

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PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 7) WEIGHT: 0.21 lbs

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MFG. APPR.	DD	D5076	SHEET 7 OF 7
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2014-03-31
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